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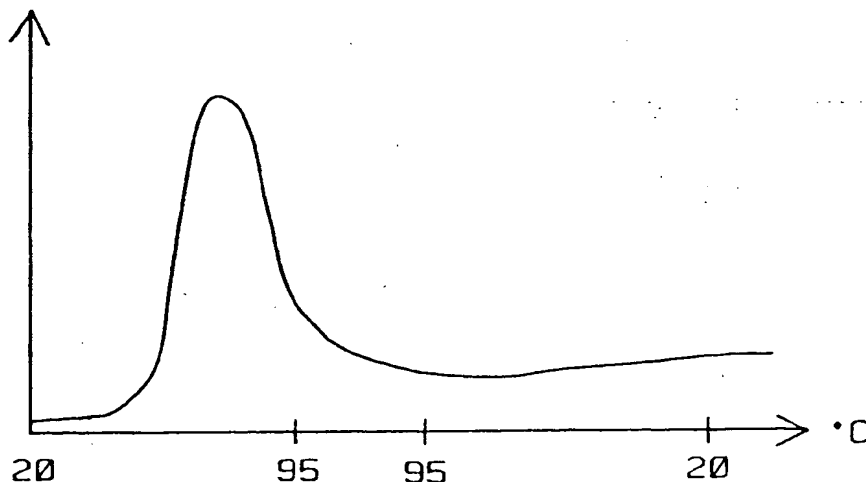
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(54) Method for the manufacture of margarine having an extra low fat content.

(57) Method for the manufacture of an extra low calorie margarine having a fat content of between 15 and 38 percent by weight, whereby a water phase comprising starch which is solved in a liquid, that can carry aroma substances and eventually also comprising a slight amount of taste giving substances and preservatives, is emulsified, batchwise or successively, in a fat phase prepared from fats and/or oils and an addition of 0.25-2 percent by weight as calculated on the ready margarine of an emulsifier and minor amounts of fat soluble aroma substances and/or vitamins to directly form a water-in-oil emulsion which is pasteurized, cooled and packed, whereby the starch included in the water phase is pretreated in a first step by being acid-hydrolysed for reducing of the viscosity of the starch in a solution, and upon need in a second step by introducing a functional group into the starch molecule for stabilizing the acid-hydrolysed starch base, whereby the starch is made completely soluble in the water phase and can be heat treated and cooled without becoming gelified.

Viscosity



**Fig. 2**

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The present invention generally relates to manufacture of low calorie margarines having an extra low fat content, for instance a fat content of between 15 and 38 percent by weight.

A method for the manufacture of such margarines is known from the Swedish patent 461.762 (corresponding to US patent No 4,978,554) in which method a protein containing water phase is emulsified in a fat phase to directly form a water-in-oil emulsion, which is pasteurized, cooled and packed, and in which the water phase is prepared:

- in a first stage, in that starch and an emulsifier are solved in skim milk, butter milk, whey, water of a mixture thereof, under stirring; the emulsifier in the water phase is used for preventing the starch from becoming gelified;
- in second stage, in that the starch-emulsifier solution is allowed to stand and swell and become "ripened" for some time, for instance for about 24 hours;
- and in a third stage in that the "ripened" starch-emulsifier solution is mixed with a protein concentrate from a milk product, with melting salts and with taste-giving substances to form a final water phase;
- whereupon the ready water phase is successively emulsified in a fat phase prepared in a conventional way;
- and the water-in-oil emulsion thereby formed is pasteurized, cooled and packed.

The said known method of manufacturing the extra low calorie margarine is expensive, there is a need for a special manufacturing equipment and a special plant for manufacturing same, and the process is rather complicated and time consuming.

The preparation and the handling of the protein material is expensive, since the preparation thereof necessitates a fermentation of the milk product and a precipitation and a separation of the protein. Also, there is a lack of protein on the market and therefore it would be good to reduce the amount of protein used for the manufacture of the actual margarine.

Further the handling of the starch is expensive depending on the time consuming and relatively complicated handling as far as to a ripened condition of the starch solution. In case of normal handling of highly concentrated starch there is a risk that the starch gellifies when a warm starch solution is being cooled, and this is not wanted. Thus, the starch solution is not "stable in solution". In the above mentioned known method such gelification is prevented in forming a starch lipid complex by adding emulsifiers of the type monoglyceride to the starch solution.

Summarizing there has been a wish to reduce the number of persons needed for the manufacture of the margarine, and to be able to use a less skilled staff; to reduce the total handling time, to get a simpler and thereby cheaper handling process for the product; to reduce the necessary storing time and get reduced storing costs of the ingredients, in particular of the starch part thereof; to reduce the amount of protein used in the margarine; to avoid the use of emulsifiers in the water phase, and to reduce the waste material in the manufacture of the margarine.

It has proved possible to meet all of the above listed requirements by using a type of starch which is pre-treated in a factory, and which is used in the manufacture of the margarine in the dairy or the margarine factory without the need of further treating the starch. In the following said starch will be referred to as "special starch".

This is possible by "acid-hydrolysating" the starch in a water suspension, whereby the starch grains are being suspended (elutriated) in water, and the suspension is heated to a temperature which is less than the temperature, at which the starch grains pastify, whereby the molecular weight becomes reduced and the viscosity in a boiling solution is reduced. The starch pre-treated accordingly is totally soluble and no starch grains remain after the starch has been boiled.

For further "stabilizing" the acid-hydrolysed starch a function group, for instance an acetylic group, an hydroxy-propylic group, an octenylic-succinylic group, a succinylic group or a similar group is coupled to the starch molecule. It is thereby possible to obtain such stabilization that the starch does not gelify in the boiled starch solution, and it has thereby been made possible to completely eliminate the need of using a monoglycerid-emulsifier which was previously needed in the starch solution.

The "special starch" thereby formed is unique in that it has a heavy viscosity peak in the pastification moment, and thereafter the solution becomes thinner and more mobile. The starch in the solution does not gelify when the solution is cooled after the heat treatment. On the contrary the viscosity remains on a low level. Compare the curve in figure 2.

For making it possible to use starch directly in a process using an available equipment in the manufacture of margarine the starch is pastified and dried on rollers, and for making it possible to simply dispersing and solving the starch it is supplied in the form of small flakes.

The attached figure 1 diagrammatically shows how the viscosity changes when the above mentioned known acid-hydrolysed starch is heated and cooled. Figure 2 correspondingly shows how the viscosity changes in the starch according to the invention, which starch has been both acid-hydrolysed and acetylated.

It is obvious from figure 1 that the viscosity of the known starch increases strongly when it is cooled (95-20°C and still lower temperature) after having been heat treated. Figure 2 shows that the viscosity of the new starch solution, the "special starch" remains on a surprisingly low level when cooled after a heat treatment, and this is a critical property which is used in the method according to the invention.

It is obvious that the viscosity of the known acid-hydrolysed starch of figure 1 increases strongly when cooled after having been heat treated. The reason for this is that the starch is normally not naturally stable. The starch according to the invention, figure 2, on the contrary, which starch is both acid-hydrolysed and to which a functional group of the acetylic, hydroxipropylic, 1-octenyl-succenylic etc. type has been added maintains a surprisingly low viscosity also when cooled after having been heat treated at a high temperature. As previously mentioned there are certain starch types which are naturally stable, and for such starch types the latter treatment stage, generally referred to as the acetylation step, may be excluded.

More in detail the "special starch" is prepared as follows:

A. The "special starch" which is of interest in the present case is prepared in that starch grains, for instance potato starch or any other type of starch, is suspended in diluted hydrochloric acid, preferably starch having a dry matter content of about 40% in an about 1,5 % hydrochloric acid. The starch suspension is stirred, whereupon it is allowed to stand for 3-5 hours. The hydrochloric acid makes the starch hydrolyse whereby the amylopectin of the starch is split into smaller parts. This is of critical importance for the succeeding use of the special starch for the manufacture of the extra low calorie margarine.

B. Preferably, but not necessarily, the excess of hydrochloric acid is washed out of the starch by means of excess of water. This is done to avoid having the starch turn gray coloured which it will otherwise do.

C. To esterify the starch with an anhydrous reagent the starch solution is neutralized with sodium hydroxide so that the pH value at a temperature of 25°C is 8-8.5 (at 40°C about pH = 7). For executing the hydroxy-propylation step the pH value is adjusted to pH = 11-12 and temperature is set to about 40-50°C.

D. For stabilizing the starch the starch solution gets a dosing of an acetic acid anhydride or, a hydroxy propylic group from propylenic oxide, or an 1-octenyl-succinic group (1-oktenyl-succinic-anhydride), or a pure succinic acid anhydride. The dosage is made according to the maximum limits which are stipulated by FAO/WHO and FDA for accepting of the starch as an additive for food stuffs. As mentioned above some starch types are naturally stable, and when using such starch types the present stage D can be excluded. Examples of such naturally stable starch types, for which the present stage D can be excluded are those types which are marketed under the English trade names Waxy Corn, Waxy Maize, Waxy Rice, Waxy Barley, Waxy Sorghum etc.

E. The pH value of the starch is adjusted to pH 5-7.

F. Finally the starch is washed and dried. The ready special starch is soluble in hot water. If the starch solution is dried on hot rollers it is possible to get a starch which is soluble even in cold water. Preferable the starch is presented in the form of quickly soluble starch flakes.

The special starch thereby obtained is very well suited for quick and simple manufacture of an extra low calorie margarine without any further treatment of the starch. By using said special starch it is possible to make margarines having fat contents down to as low as 10%, whereby the starch content of the product is between 5 and 13 percent by weight. If protein is added to the product the starch content can be kept as low as even down to 2 percent by weight (compare the following example 7).

Generally the extra low calorie margarine according to the invention is manufactured in four successive simple method steps, namely: I preparing the water phase, II preparing the fat phase, III emulsifying the water phase in the fat phase and IV final treatment.

#### I. Preparing the water phase.

The special starch prepared as described above is in a simple method step solved in any type of liquid which can carry the aroma substances, for instance in water, skim milk, soured (cultured) milk, butter milk, whey, yoghurt, low concentrated milk protein, soy protein or any other vegetable protein. The starch is preferably solved in a warm liquid, for instance a liquid having a temperature of 50-70°C. The amount of starch in relation to liquid ought to be such that the dry matter content of the starch in the water phase, as calculated on the final product, is 8-15 percent by weight or preferably 10-12 percent by weight for a margarine having a fat content of 15-25 percent by weight. For margarines having a higher fat content the amount of starch can be reduced, for instance to a dry matter content of 6-12 or preferably 8-10 percent by weight for a margarine having 25-39 percent fat content. To the starch solution is added salt and aroma substances like butter aroma, and preservatives like potassium sorbate. Eventually, but not necessarily, also protein concentrate may be added. Thanks to the use of the above described "special starch" it is possible to avoid using an emulsifier, which was previously necessary, and this is due to the fact that the special starch itself prevents gelification. The

temperature of the water phase is maintained at about 45-60°C so that it can immediately be emulsified in the fat phase.

## II. Preparing the fat phase.

The fat phase is prepared, as known per se, from fats and/or oils of conventional type, which are mixed with each other at a temperature of 48-65°C. To the liquid fats/oils is added 0.25 - 2 % of a known emulsifier like a monoglyceride. The emulsifier has two functions, firstly to facilitate the emulsification and secondly to foresee that the products gets the desired fat crystal formation. To the warm fat phase is also added, if desired, small amounts of fat soluble vitamins and colour substances like betacarotene. The temperature of the fat phase is maintained at about 48-65°C.

## III. Emulsification.

The warm water phase (45-60°C) and the warm fat phase (48-65°C) can be emulsified either by, slowly and under intense working, pumping the water phase into the fat phase, or by emulsifying the water phase and the fat phase batchwise in mixing tanks, likewise under intense mechanical working. Generally it is preferred to slowly and successively dose the water phase into the fat phase for margarines having fat contents within the low fat area, e.g. fat contents of 15-25, whereas the batchwise process can be used for emulsification of the water and fat phases at higher fat contents of e.g. 25-38%.

## IV. Final treatment.

The emulsion that formed under point III is pasteurized, for instance by being pumped through scraper pasteurizing apparatus, whereby the product is heated to a pasteurization temperature of 80-85°C, whereafter it is quickly cooled to 15-10°C by being passed through a scraper heat exchanger of known type. After the margarine has been cooled it is worked in a working step and is packed as known per se.

In the following there will be given a number of examples on the manufacture of margarines having as low fat contents as between 15 and 8 percent by weight. In all examples there is used the "special starch" described above, and it is simply referred to the above process steps A-F as concerns the manufacture of the "special starch".

### EXAMPLE 1 (25% fat content)

#### PREPARING THE WATER PHASE:

18.8 kg butter milk was neutralized and was heated to 60°C. In the warm milk was solved 3.3 kg of the above described acid hydrolyzed and acetylated "special starch" under intense stirring. To the solution was added 0.4 kg common salt (NaCl) and a little amount of a water soluble aroma substance, for instance some type of cultured milk distillate, for taste reasons of the product, and 0.01 kg potassium sorbate as a preservative. The solution was allowed to stand at maintained temperature for about an hour, during which period the solution was stirred, and thereafter there appeared a quite smooth product without any air content. Water was added so that the total weight was 22.5 kg.

#### PREPARING THE FAT PHASE

7.1 kg butter oil was heated to 65°C, and to the warm butter oil was added 0.3 kg emulsifier of the monoglyceride type, a colouring substance in a solution form, for instance butter colour or betacarotene, vitamins and fat soluble aroma, for instance Alvetto. The total weight of the fat phase was 7.5 kg.

#### EMULSIFICATION

The fat phase was transferred to an emulsification tank having a stirring mill which can be rotated at variable speeds. To the warm fat phase (65°C) was successively added the warm water phase (60°C). The stirring mill was operated at an optimum speed while the water phase was mixed into the fat phase. Said optimum speed is a speed at which no air is introduced in the emulsion, but the speed is still so high that a perfect emulsion of the type water-in-oil (W/O) is obtained. The total weight of the emulsion was 22.5 + 7.5 = 30 kg.

## FINAL TREATMENT

The emulsion was pasteurized by being pumped through a scraper pasteurizing unit, whereby the emulsion was heated to 80-85°C, whereupon the emulsion was quickly cooled to 15-10°C by a known technique, by means of a scraper heat exchanger. The margarine was finally worked in a working step and was thereafter packed.

## CONCLUSION / JUDGEMENT

The margarine obtained by the process had an emulsion of the type water-in-oil, and it had a fat content of only 25%. The margarine could be made a W/O emulsion and could be pasteurized and cooled thanks to the presence of the new type of starch, the "special starch" described above, solved in neutralized butter milk. A skilled sample panel judged the taste of the margarine to 4.2 of a 5-grade scale, and the consistency of the margarine was judged 4.1.

## EXAMPLE 2 (15% fat content)

## PREPARING THE WATER PHASE

3.8 kg of the above described special starch was solved under intense stirring in 21.5 kg skim milk heated to 55°C. For taste giving purposes there was added to the solution 0.5 kg common salt and a little amount of a water soluble aroma of known standard type, and in addition thereto was added 0.02 kg potassium sorbate as a preservative. The solution was stirred for about 2 hours in warm condition, after the lapse of which period a quite smooth solution without any admixture of air had been obtained. Water was added so that the total weight was 25.2 kg.

## PREPARING THE FAT PHASE

3.6 kg butter oil was heated to 65°C, and to the warm butter oil was added 0.6 kg emulsifier of the mono-glyceride type, a colouring solution, vitamins and fat soluble aroma substances. The total weight of the fat phase was 4.5 kg.

## EMULSIFICATION

The fat phase was transferred to an emulsification tank having a variable speed stirring mill and into the warm fat phase the warm water phase was successively admixed while the stirring mill was run at optimum speed, which is such high speed that a perfect emulsion of the water-in-oil type is obtained during the entire admixture time without any air being introduced in the emulsion. The total weight of the emulsion was 30 kg. Depending on the extremely low fat content (15%) it was necessary to add the water phase extremely slowly.

## FINAL TREATMENT

The above formed emulsion was pasteurized by being pumped through a scraper pasteurizing unit, in which the emulsion was heated to 82-85°C, whereupon it was quickly cooled to 15-13°C by known techniques on a scraper heat exchanger. After the final treatment the margarine was packed.

## CONCLUSION / JUDGEMENT

A margarine of the water-in-oil type having only 15% fat content could be made according to the present example by a mixing, pasteurization and a cooling process. This was possible since the water phase contained the above new special starch solved in skim milk. A skilled sample/judgement panel judged the margarine having a taste of 3.8 on a 5-grade scale, and the consistency was judged to 3.7 according to the same scale. Depending on the extremely low fat content of the margarine it was difficult to get high evaluation points as concerns taste and consistency.

EXAMPLE 3 (38% fat content)

PREPARING THE WATER PHASE

5 15.4 kg neutralized butter milk was heated to 58°C and 2.7 kg of the above mentioned special starch was solved in said warm butter milk under intense stirring. For taste reasons 0.6 kg common salt and a little amount of water soluble aroma substances were added to the solution, and 0.01 kg potassium sorbate was added as a preservative. The solution was stirred for about 1 hour at maintained temperature, after the lapse of which period a quite smooth solution without any admixture of air had been obtained. Water was added to a total weight of 18.6 kg.

PREPARING THE FAT PHASE

15 6.4 kg butter oil was heated to 65°C and 0.075 kg of a monoglyceride emulsifier was added to the butter oil. Further, there was added a colouring solution, vitamins and small amounts of fat soluble aroma substances. Finally sunflower oil was added so that the final weight of the fat phase was 11.4 kg.

EMULSIFICATION

20 The fat phase was transferred to an emulsification tank having a variable speed stirring mill. The warm water phase was successively mixed into the warm fat phase. The stirring mill was run at optimum speed during the mixing of the water phase into the fat phase, which speed is such that there is no admixture of air but which is still so high that a quite acceptable emulsion of the type water in oil is obtained during the entire period at which the water phase is mixed into the fat phase. The temperature of the emulsion was kept at 47°C. The total weight of the emulsion was 30 kg.

FINAL TREATMENT

30 The emulsion was pasteurized on a scraper pasteurizing apparatus at a temperature of 87-90°C, whereafter the emulsion was quickly cooled to 11-9°C by being passed through a scraper heat exchanger according to known technics. Finally the margarine was worked and packed.

CONCLUSION / JUDGEMENT

35 It was established that the emulsion of the product was of the type water in oil and that the product had a fat content of 38%. There were no problems in forming the emulsion thanks to the presence of the actual special starch solved in neutralized buttermilk. A skilled taste sample/judgement panel concluded that the product had a taste of 4.3 according to a 5-grade scale and a consistency of 4.4 according to the same scale. The margarine had a fresh buttermilk taste but was judged slightly too salt.

40 For considering the influence of the liquid in which the special starch of the water phase is solved the following examples 4 and 5 were made.

EXAMPLE 4 (27% fat content)

45 PREPARING THE WATER PHASE

50 A water phase was prepared by solving 3.9 kg special starch in 18.1 kg neutralized yoghurt heated to a temperature of 60°C under intense stirring. To the solution was added 0.4 kg common salt and a slight amount of water soluble aroma substances, and also 0.01 kg potassium sorbate as a preservative. The solution was stirred for about 30 minutes, whereafter water was added so that the total weight of the water phase was 21.9 kg.

PREPARING THE FAT PHASE

55 The fat phase was prepared by 7.0 kg butter oil which was heated to 65°C and to which was added 0.2 kg of an emulsifier of the monoglyceride type, a colouring solution, vitamins and fat soluble aroma substances. Soy oil was added so that the total weight of the fat phase was 8.1 kg.

## EMULSIFICATION

The warm water phase was mixed into the warm fat phase as metioned in previous examples and a total weight of 30 kg emulsion was obtained.

## FINAL TREATMENT

The margarine was pasteurized, quick-cooled, worked and packed lilke in previous examples.

## CONCLUSION / JUDGEMENT

The margarine was of the type W/O and had a fat content of 27%. The taste was judged to 4.1 and the consistency to 4.3 of a 5-grade scale. The yoghurt taste was to some extent left in the ready product. The relatively high evaluation of the consistence depends on the content of soy oil which content was about 128 of the total fat content.

### EXAMPLE 5 (30% fat content)

#### PREPARING THE WATER PHASE

A water phase was prepared by solving 3.1 kg special starch under intense stirring in 17.5 kg neutralized cheese whey heated to 60°C. To the solution was added 0.4 kg common salt and a little amount of water soluble aroma substances, and 0.01 kg potassjum sorbate as a preservative. The solution was stirred for about 1 hour, whereby a smooth and air-free solution was obtained. Water was added so that the total weight of the water phase was 21.0 kg. The temperature was set to 60°C.

#### PREPARING THE FAT PHASE

The fat phase was prepared from 6.4 kg butteroil which was heated to 65°C and to which was added 0.2 kg emulsifier in the form of a monoglyceride, a colouring solution, vitamins and fat soluble aroma substances. Sunflower oil was added so that the total weight of the fat phase was 9.0 kg.

## EMULSIFICATION

The water phase was mixed into the fat phase like in the previous examples, and a total weight of 30 kg emulsion was obtained.

## FINAL TREATMENT

The margarine was pasteurized at 86-88°C and was thereafter quickly cooled, worked and packed like in the previous examples.

## CONCLUSION / JUDGEMENT

The margarine was of the type W/O and had a fat content of 30%. The taste was judged to 4.0 and the consistency to 4.2 on a 5-grade scale. The cheese whey taste was to some extent remained in the final product.

### EXAMPLE 6 (38% fat content)

#### PREPARING THE WATER PHASE

A water phase was prepared in that 2.7 kg special starch was solved under intense stirring in 15.4 kg neutralized buttermilk heated to 58°C. To the solution was added 0.4 kg common salt and a little amount of water soluble aroma substances, and 0.01 kg potassium sorbate as a preservative. The solution was stirred for about 1 hour, whereafter a smooth and air-free solution had been obtained. Water was added so that the total weight of the water phase was 18.6 kg.

## PREPARING THE FAT PHASE

The fat phase was prepared like in example 3 from 6.4 kg butter oil which was heated to 65°C, but to the melted fat was in this case added only 0.025 kg of a monoglyceride emulsifier, corresponding to only 0.08% emulsifier as calculated on the final product. A colour solution, vitamins and fat soluble aroma substances were added. Further, sunflower oil was added so that the total weight of the fat phase was 11.4 kg.

## EMULSIFICATION

The water phase was mixed into the fat phase like in the previous examples, and a total weight of 30 kg emulsion having a temperature of 47°C was obtained.

## FINAL TREATMENT

The margarine was pasteurized at 87-90°C and was quickly cooled, and was worked and packed like in the previous examples.

## CONCLUSION / JUDGMENT

The margarine was of the type W/O and had a fat content of 38%. The taste was judged to 4.3 and the consistency to 2.4 of a 5-grade scale. The margarine had a fresh buttermilk taste, but after having been stored for some time it proved to have got a grainy consistency depending on the low amount of emulsifier, which gave the product a defective fat crystal formation resulting in the low evaluation of the consistency. This example shows that there is a lower limit for the amount of added emulsifier, which in this case corresponds to only 0.08% emulsifier as calculated on the final product.

Resulting from a set of test with manufacture of the same product but having a successively increased amount of emulsifier it proved that a quite satisfactory fat crystal formation was not observed until the amount of emulsifier came close to 0.25% as calculated on the final product.

For judging the influence of a further increasing amount of emulsifier a set of tests were made with manufacture of the same product, whereby it proved that the amount of emulsifier, without detrimental influencing the product but also without any remarkable improvement of the product could be increased up to about 2% as calculated on the final product. At said high value the viscosity was growing so high that it was difficult to handle and to pump the product. Therefore it could be considered that the upper limit for the amount of added emulsifier was reached at about 2% addition of emulsifier. Empirically it could be established that the necessary amount of the emulsifier addition for obtaining a good final product decreases at an increasing fat content, and that the need of emulsifier at a fat content of 38% is only 5-10% of the necessary amount of emulsifier for margarines having a fat content of as low as about 15%.

For judging the influence of the added amount of special starch the following examples 7 and 8 were made.

### EXAMPLE 7 (38% fat content)

## PREPARING THE WATER PHASE

A water phase was prepared in that 0.6 kg special starch was solved under intense stirring in 17 kg of a protein solution from buttermilk heated to 58°C. The protein content of the solution was 13%. To the starch/buttermilk solution was added 0.5 kg common salt and a slight amount of water soluble aroma substances, and 0.01 kg potassium sorbate as a preservative. The solution was stirred for about 1 hour, whereafter a smooth and air-free solution was present. Water was added so that the total weight of the water phase was 18.6 kg after the pH had been set to 6.3 by an addition of melting salts of the type Na-phosphates and Na-citratés. The final temperature of the water phase was 48°C.

## PREPARING THE FAT PHASE

The fat phase was prepared like in the above example 6 from 6.4 kg butter oil heated to 65°C. To the melted fat was added 0.075 kg of a monoglyceride emulsifier, corresponding to only 0.25% emulsifier as calculated on the final product. Further there was added a colour solution, vitamins and fat soluble aroma substances. Sunflower oil was added so that the total weight of the fat phase was 11.4 kg.



## EMULSIFICATION

The water phase was mixed into the the fat phase like the previous examples. In total 30 kg emulsion having a temperature of 49°C was obtained.

## FINAL TREATMENT

The margarine was pasteurized at 87-90°C and was quickly cooled, and was worked and packed like in the previous examples.

## CONCLUSION / JUDGEMENT

The margarine was of the type W/O and had a fat content of 38%. The taste was judged to 4.4 and the consistency to 4.4 of a 5-grade scale. The margarine had a fresh buttermilk taste and a good consistency.

## EXAMPLE 8 (38% fat content)

## PREPARING THE WATER PHASE

A water phase was prepared in that 2.0 kg special starch was solved under intense stirring in 15 kg of a protein concentrate from skim milk heated to 58°C. The protein content of the solution was 10%. To the solution was added 0.5 kg common salt and a slight amount of water soluble aroma substances, and 0.01 kg potassium sorbate as a preservative. The solution was stirred for about 3 hours, whereafter a smooth and air-free solution was present. Water was added so that the total weight of the water phase was 18.6 kg. The final temperature of the water phase was 48°C.

## PREPARING THE FAT PHASE

The fat phase was prepared like in the above example 7 from 6.4 kg butter oil, which was heated to 65°C. To the melted fat was added 0.075 kg of a monoglyceride emulsifier, corresponding to only 0.25% emulsifier as calculated on the final product. A colour solution, vitamins and fat soluble aroma substances were added. Further rape oil was added so that the total weight of the fat phase was 11.4 kg.

## EMULSIFICATION

The water phase was mixed into the fat phase like in the previous examples and a total weight of 30 kg emulsion having a temperature of 49°C was obtained.

## FINAL TREATMENT

The margarine was pasteurized at 87-90°C and was thereafter quickly cooled, worked and packed like in the previous examples.

## CONCLUSION / JUDGEMENT

The margarine was of the type W/O and had a fat content of 38%. The taste was judged to 4.4 and the consistency to 4.4 of a 5-grade scale. The margarine had a fresh skim milk taste and a good consistency.

The following examples 9 and 10 are intended to show that there is an upper limit for the addition of the special starch.

## EXAMPLE 9 (15% fat content)

## PREPARING THE WATER PHASE

A water phase was prepared in that 4.5 kg of the special starch was solved under intense stirring in 20.5 kg skim milk heated to 58°C. To the solution was added 0.5 kg common salt, a little amount of water soluble aroma substances, and 0.02 kg potassium sorbate as a preservative. The solution was stirred for about 1 hour, whereafter a smooth and air-free solution was present. Water was added so that the total weight of the water

phase was 25.5 kg. The water phase was very thick.

#### PREPARING THE FAT PHASE

5 The fat phase was prepared like in example 2 from 3.6 kg butter oil heated to 65°C. To the melted fat was added 0.6 kg of a monoglyceride emulsifier, corresponding to only 0.25% emulsifier as calculated on the final product. Further a colour solution, vitamins and fat soluble aroma substances were added, and finally rape oil was added so that the total weight of the fat phase was 4.5 kg.

#### 10 EMULSIFICATION

The water phase was mixed into the fat phase like in the previous examples and there was obtained a total weight of 30 kg emulsion having a temperature of 49°C. Due to the extremely low fat content it was necessary to add the water phase extremely slowly.

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#### FINAL TREATMENT

The margarine was pasteurized at 82-85°C and was cooled quickly, was worked and was packed like in the previous examples.

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#### CONCLUSION / JUDGEMENT

The margarine was of the type W/O and had a fat content of only 15%. The taste was judged to 3.5 and the consistency to 3.2 of a 5-grade scale. The margarine had a rather thick consistency.

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#### EXAMPLE 10 (15% fat content)

#### PREPARING THE WATER PHASE

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A water phase was prepared in the 5.1 kg of the special starch was solved under intense stirring in 20.0 kg skim milk heated to 58°C. To the solution was added 0.4 kg common salt and a little amount of water soluble aroma substances, and 0.03 kg potassium sorbate as a preservative. The solution was stirred at maintained temperature for about 2 hours, whereafter smooth and air-free solution was present. Water was added so that the total weight of the water phase was 25.5 kg. The water phase was very thick even at such high temperature as 65°C.

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#### PREPARING THE FAT PHASE

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The fat phase was prepared like in example 9 from 3.6 kg butter oil heated to 65°C. To the melted fat was added 0.6 kg of a monoglyceride emulsifier, corresponding to only 0.25% emulsifier as calculated on the final product. Further there was added a colour solution, vitamins and fat soluble aroma substances. Rape oil was finally added so that the total weight of the fat phase was 4.5 kg.

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#### EMULSIFICATION

The water phase was mixed into the fat phase like in the above examples, and a total weight of 30 kg emulsion having a temperature of 49°C was obtained. Due to the extremely low fat content it was necessary to add the water phase extremely slowly.

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#### FINAL TREATMENT

It was not possible to pasteurize and cool the product since it had a too high viscosity for being pumped through the scraper pasteurizing unit and the heat exchanger.

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#### CONCLUSION / JUDGEMENT

The example 10 shows that it was not possible to obtain a margarine since the water phase had a too high viscosity and this in turn is depending on the high amount of special starch added to the water phase, which

amount corresponds to 17% of the total weight of the water phase and the fat phase.

# COMPILATION OF EXAMPLES

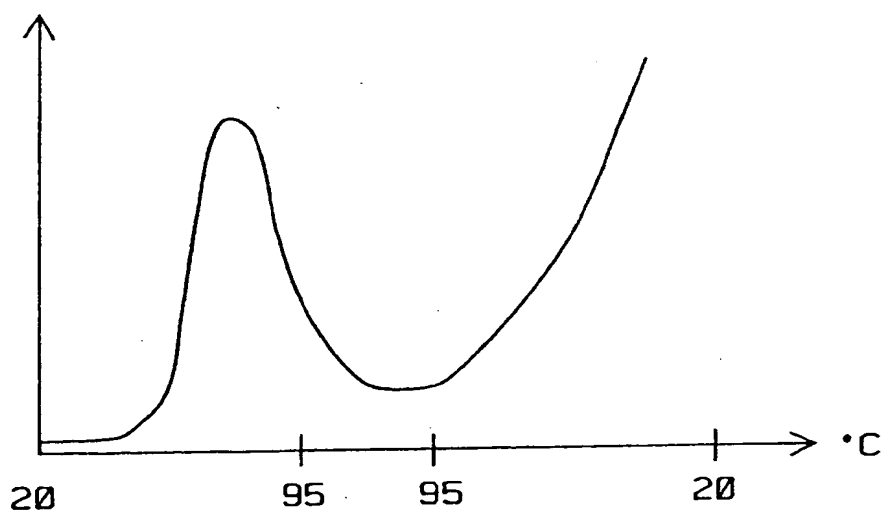
Example nr	Fat content % in total	Starch		Emulsifier % in total	Judgement (5)	
		solved in	% in total		taste	consist.
1	25	butter m	11	1.0	4.2	4.1
2	15	skim m	12.7	2.0	3.8	3.7
3	38	butter m	9	0.25	4.3	4.4
4	27	yoghurt	10	0.7	4.1	4.3
5	30	cheese whey	10.3	0.7	4.0	4.2
6	38	butter m	9	0.08	4.3	2.4
7	38	but.m.prot.	2	0.25	4.4	4.4
8	38	sk.m.prot.	6.7	0.25	4.3	4.4
9	15	skim m	15	2.0	3.5	3.2
10	15	skim m	17	2.0	---	---

## Claims

- Method for the manufacture of an extra low-calorie margarine having a fat content of between 15 and 38 percent by weight as calculated on the final product, whereby a water phase comprising starch, which is solved in any liquid that can carry aroma substances and further eventually comprising taste giving substances and preservatives, is emulsified, batchwise or successively, in a fat phase prepared by fats and/or oils and a little addition of an emulsifier and minor amounts of fat soluble aroma substances and/or vitamins to directly form a water-in-oil emulsion which is pasteurized, cooled and packed, **characterized** in that the starch included in the water phase is pretreated in a first step by being acid hydrolysed for reducing of the viscosity of the starch in a solution, and, for those types of starch which are not naturally stable, in a second step by introducing a functional group into the starch molecule for stabilizing the acid hydrolysed starch base, whereby the starch has been made completely soluble in the water phase and can be heat treated and cooled without becoming gelified.
- Method according to claim 1, **characterized** in that the starch is added in an amount of between 2 and 15 percent by weight as calculated on the ready margarine.
- Method according to claim 1 or 2, **characterized** in that an emulsifier, for instance a monoglyceride, is added to the fat phase in an amount of 0.25 - 2 percent by weight as calculated on the ready margarine.
- Method according to claim 1, 2 or 3, **characterized** in that the starch of the water phase is solved in water or any milk product like buttermilk, skim milk, soured (cultured) milk, cheese whey, yoghurt, low concentrated milk protein, or in soy protein or another vegetable protein.
- Method according to any of the preceding claims, **characterized** in that the starch is solved in a warm liquid, for instance a liquid having a temperature of 50-70°C.
- Method according to any of the preceding claims, **characterized** in that the concentration of the starch is such that the dry matter content of the starch is 8-15 or preferably 10-12 percent by weight as calculated on the final product for a margarine having a fat content of 15-25 percent by weight, whereas the dry matter content of the starch is 2-8 percent by weight as calculated on the ready product for margarines having a fat content of 25-38 percent by weight.

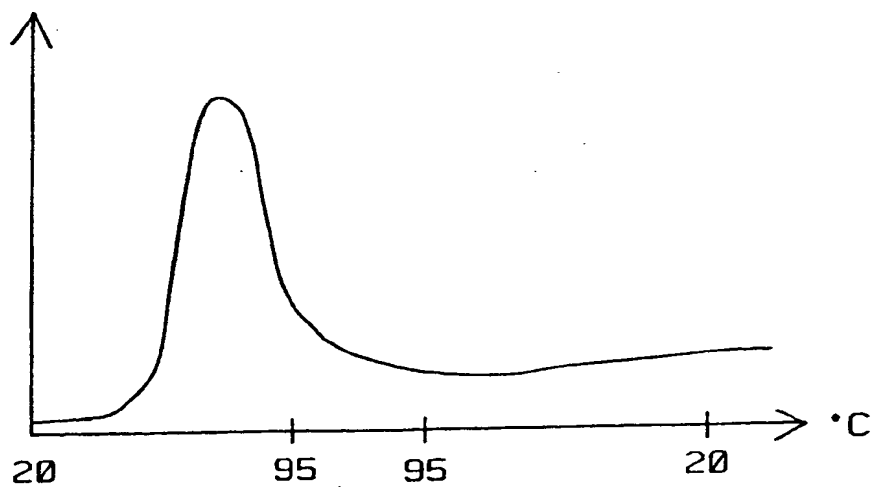
7. Method according to any of the preceding claims, **characterized** in that salt and aroma substances like butter aroma is added to the water phase for taste reasons, and a preservative like potassium sorbate and eventually some amount of protein concentrate.
- 5 8. Method according to any of the preceding claims, **characterized** in that the starch is solved in the liquid of the water phase at a temperature of 48-65°C, and in that the water phase is emulsified in the fat phase under intense mechanical working and either by a slow injection thereof into the fat phase, or by batchwise admixture of the water phase in the fat phase in mixing tanks, and whereby the temperatures of both the water phase and the fat phase are maintained at their respective preparation temperatures.
- 10 9. Method according to any of the preceding claims, **characterized** in that the starch is pretreated by
  - suspending starch grains in diluted hydrochloric acid, for instance suspending potato starch having a dry matter content of about 40% in a 1.5% hydrochloric acid,
  - stirring the suspension and allowing the suspension to stand for 3-5 hours,
  - 15 - washing out the excess of hydrochloric acid from the starch by means of water,
  - neutralizing the starch solution by means of sodium hydroxide so that the pH value at a temperature of 25°C is 8-8.5 (at 40°C about pH = 7), or, for reacting the starch solution with propylene oxide pH about 11-12 at a temperature of about 40°C,
  - 20 - stabilizing those starch types which are not naturally stable by coupling to the starch an acetylic group, a hydroxi-propionic group, an 1-oktenylsuccinyl group or pure succinic acid in an amount corresponding to the standards of FAO/WHO for food additives,
  - setting the pH value of the starch to pH 5-7,
  - and finally washing and drying the starch, for instance drying the starch on heated rollers.

Viscosity



**Fig. 1**

Viscosity



**Fig. 2**

(19)



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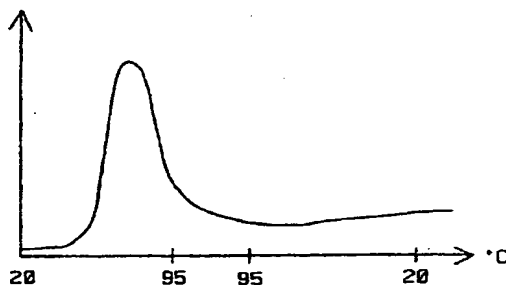
(11) Publication number : **0 537 126 A3**

(12)

**EUROPEAN PATENT APPLICATION**(21) Application number : **92850021.4**(51) Int. Cl.<sup>5</sup> : **A23D 7/02, A23C 15/16,  
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**15.06.94 Bulletin 94/24**(71) Applicant : **L & L INTERNATIONAL SWEDEN  
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Torsgatan 114  
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S-533 00 Götene (SE)**(74) Representative : **Avellan-Hultman, Olle  
Avellan-Hultman Patentbyrå AB  
P.O. Box 5366  
S-102 49 Stockholm (SE)**(54) **Method for the manufacture of margarine having an extra low fat content.**

(57) Method for the manufacture of an extra low calorie margarine having a fat content of between 15 and 38 percent by weight, whereby a water phase comprising starch which is solved in a liquid, that can carry aroma substances and eventually also comprising a slight amount of taste giving substances and preservatives, is emulsified, batchwise or successively, in a fat phase prepared from fats and/or oils and an addition of 0.25-2 percent by weight as calculated on the ready margarine of an emulsifier and minor amounts of fat soluble aroma substances and/or vitamins to directly form a water-in-oil emulsion which is pasteurized, cooled and packed, whereby the starch included in the water phase is pretreated in a first step by being acid-hydrolysed for reducing of the viscosity of the starch in a solution, and upon need in a second step by introducing a functional group into the starch molecule for stabilizing the acid-hydrolysed starch base, whereby the starch is made completely soluble in the water phase and can be heat treated and cooled without becoming gelified.

Viscosity

**Fig. 2****EP 0 537 126 A3**



European Patent  
Office

# EUROPEAN SEARCH REPORT

Application Number  
EP 92 85 0021

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
X	EP-A-0 327 288 (GOODMAN FIELDER INDUSTRIES LTD) * page 2, line 6 - line 15 * * page 3, line 17 - line 39; claims; examples 1,6 *	1-8	A23D7/02 A23C15/16 A23D7/00
X	US-A-4 536 408 (MOREHOUSE ET AL.) * column 3, line 40 - column 4, line 8; claim 1; example 5 *	1,4,7	
A	EP-A-0 256 712 (ST. IVEL LTD) * page 2, line 30 - line 36 * * examples *	1-8	
D,A	EP-A-0 312 514 (L & L INTERNATIONAL SWEDEN AB)		
A	EP-A-0 363 741 (NATIONAL STARCH AND CHEMICAL CORPORATION)		
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			A23D C08B A23B
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 21 April 1994	Examiner Lepretre, F
<p><b>CATEGORY OF CITED DOCUMENTS</b></p> <p>X : particularly relevant if taken alone  Y : particularly relevant if combined with another document of the same category  A : technological background  O : non-written disclosure  P : intermediate document</p> <p>T : theory or principle underlying the invention  E : earlier patent document, but published on, or after the filing date  D : document cited in the application  L : document cited for other reasons</p> <p>&amp; : member of the same patent family, corresponding document</p>			

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